

Date: Tuesday, 05/02/2008 11:16:09 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	CONSOLE
<b>Job Number</b> :	37215		
<b>Estimate Number</b> :	10910		
<b>P.O. Number</b> :		<b>Part Number</b> :	D33631
<b>This Issue</b> :	05/02/2008	<b>Drawing Number</b> :	D3363 REV C
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	//	<b>Drawing Revision</b> :	C
<b>Previous Run</b> :	37087	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	12/02/2008
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	2 / 4 Um: Each
<b>Comment</b> :	Est: B 05.09.09 Remove c'sink rivet holes and add welding stepK J/JLM Est: C 06.11.15 waterjet EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S063	6061-T6 .063 Sheet
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**Comment:** Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s)  
 6061-T6 .063 thick aluminum Sheet  
 Batch: 105225 LB 8-2-S

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3363  
 Dwg Rev: C LB 8-2-S  
 Prog Rev: C

2-Deburr if necessary LB 8-2-S

② NO MATERIAL

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	BRAKE NC	NC BRAKE
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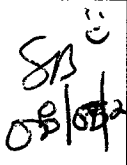
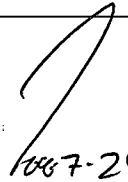
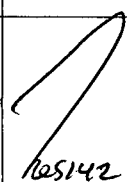
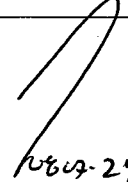
**Comment:** NC BRAKE  
 Deburr  
 Form as per Dwg D3363

503 08/05/21 ⑥

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3363-1 PAR #: N/A Fault Category: Prod / Fin. Ass med #30001 NCR: (Yes) No DQA: D Date: 08/08/01  
 QA: N/C Closed: D Date: 08/08/01

NCR: <u>37215</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/21	5	- 1 part corner crack at the bend R.C: inside corner was not deburred enough resulting in a square edge (sharp) and cracked when bending		Scrap - destroy	 08/08/21	 1007-24	 105142	 10612-24

NOTE: Date & initial all entries

Date: Tuesday, 05/02/2008 11:16:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 37215

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/24 (40)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using DT8790 as per Dwg D3363 and QSI 004

AD 08/07/25 (1)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 08/07/25 (1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/25 (40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

st238A

C 8/25 (1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/01 (1)

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

**HAWKESBURY, ONTARIO, CANADA**

**SHEET 1 OF 3**

DESIGN	<i>P41</i>	DRAWN BY	<i>P41</i>	<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
DATE	<i>3</i>			D3363	SHEET 1 OF 3
				TITLE	SCALE

07.01.26

## CONSOLE ASSEMBLY

1:5

A

04.11.29

NEW ISSUE

---

B

05.03.28

INCREASE WIDTH BY 0.125

10

07.01.26

DRILL DZUS RAIL, WIDEN BASE CUIOUI

RELEASED

07.06.04

- TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL  
THROUGH D3363-1 CONSOLE (TYP 4 PLACES)  
C'SINK (Ø0.225 X 100")  
FROM TOP SIDE OF CONSOLE

**C**

**DETAIL C**  
(SCALE 1:2)

✓C'SINK THIS SIDE (REF)

- INSTALL D3361-1 & D3362-1 USING  
MS20426AD4-6 RIVETS  
(TYP 9 PLACES)

- TRANSFER DRILL #30 FROM  
MATING PARTS THROUGH #40  
HOLES IN D3363-1 CONSOLE  
(TYP 49 PLACES) C'SINK  
(Ø0.225 X 100") FROM  
CONSOLE TOP SIDE

- INSTALL D3360-1/-3/-5 ANGLES USING  
MS20426AD4-5 RIVETS  
(TYP 44 PLACES)

D3363-1 CONSOLE

### PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

$$5.365 \pm 0.005$$

D3360-1 ANGLE

D3362-1 DZUS RAIL  
(TYP 2)

D3361-1 CHANNEL

D3360-3 ANGLE  
(TYP 2)

D3360-5 ANGLE  
(TYP 2)

$$6.363^{+0.010}_{-0.000}$$

D3360-1 ANGLE

ALIGN EDGES OF ANGLES W/CUTOUT

### VIEW A-A FROM UNDER CONSOLE ASSEMBLY

### D3383-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

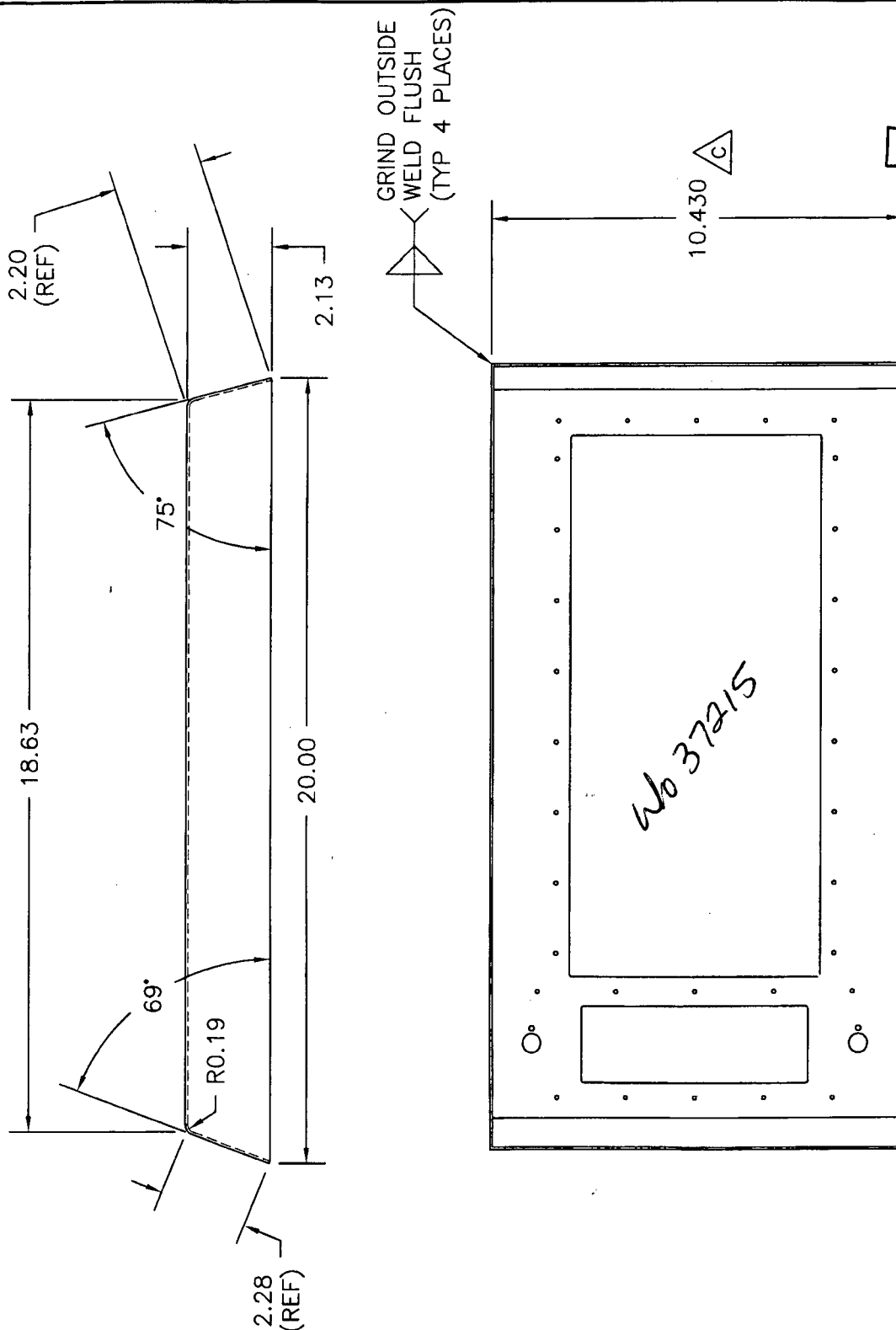
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CHECKED <i>JS</i>	APPROVED <i>PH</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4



**RELEASED**

07.06.04 *PH*

**D3363-1 BEND DETAIL**  
(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

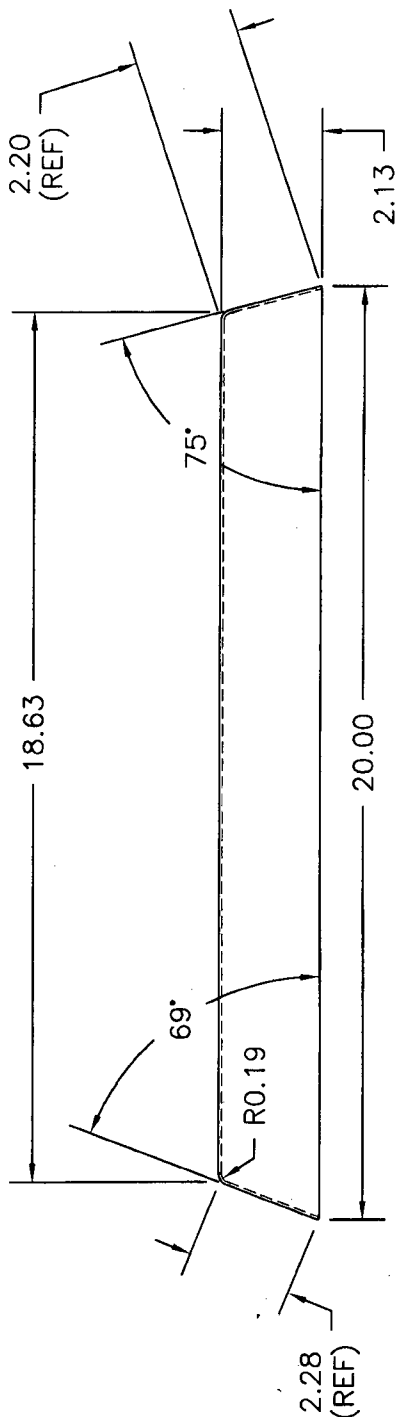
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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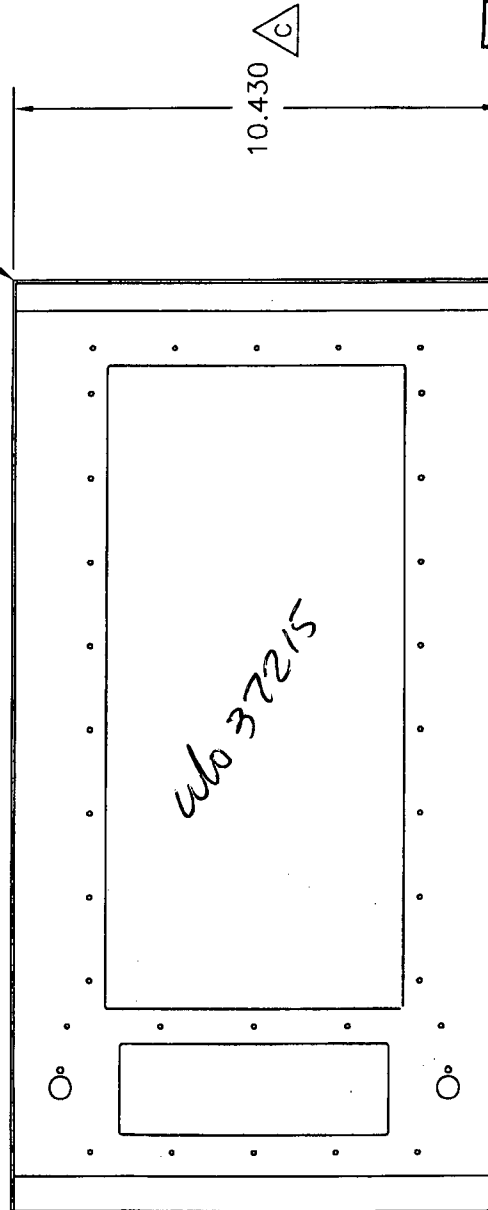
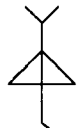
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DATE 07.01.26		TITLE CONSOLE ASSEMBLY	SCALE 1:4



GRIND OUTSIDE  
WELD FLUSH  
(TYP 4 PLACES)



RELEASED

07.06.04 *JS*

**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

**D3363-1 CONSOLE**

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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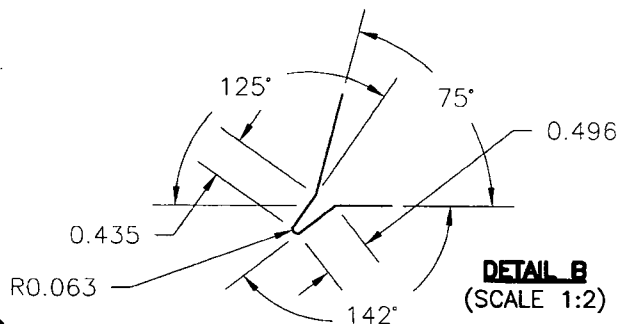
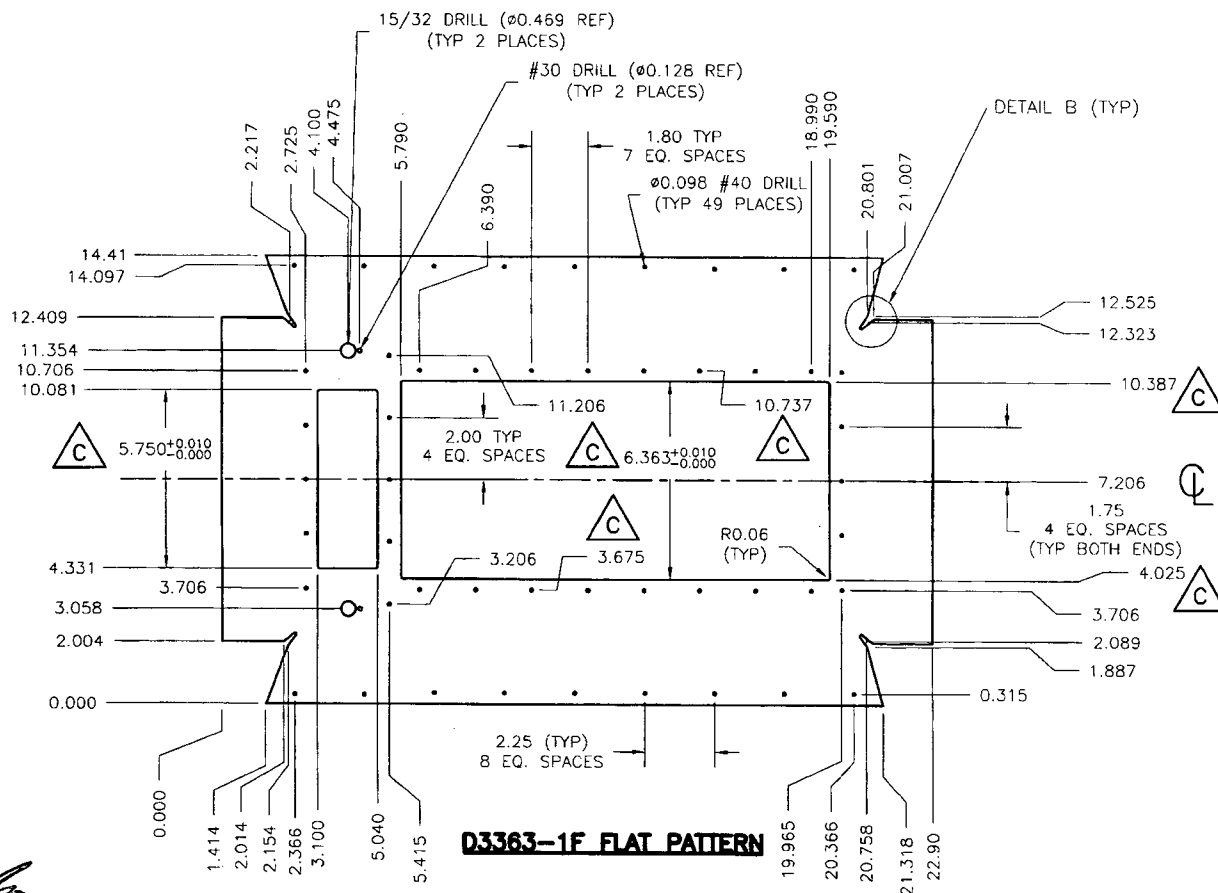
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CHECKED	APPROVED	DRAWING NO.	SHEET 3 OF 3
3		D3363	
DATE		TITLE	SCALE
07.01.26		CONSOLE ASSEMBLY	1:6

**RELEASED**

07.06.04



**D3363-1F CONSOLE (FLAT PATTERN)**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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
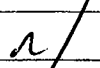


DART AEROSPACE LTD		Work Order: 37215
Description: CONSOLE		Part Number: D3363-1
Inspection Dwg: D3363-1 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.106	X			
Ø .128	+ .005 - .001	.127	✓			
Ø .469	+ .006 - .001	.469	✓			
.1315	+/- .010	.1315	✓			
22.90	+/- .030	22.90	✓			
14.41	+/- .030	14.41	✓			
2.004	+/- .010	2.004	✓			
3.058	+/- .010	3.058	✓			
4.331	+/- .010	4.335	✓			
5.750	+/- .010	5.748	✓			
10.081	+/- .010	10.081	✓			
10.706	+/- .010	10.706	✓			
11.354	+/- .010	11.354	✓			
12.409	+/- .010	12.409	✓			
14.097	+/- .010	14.097	✓			
2.336	+/- .010	2.336	✓			
3.100	+/- .010	3.107	✓			
5.040	+/- .010	5.043	✓			
5.415	+/- .010	5.415	✓			
3.206	+/- .010	3.215	✓			
3.675	+/- .010	3.675	✓			
19.965	+/- .010	19.965	✓			
20.366	+/- .010	20.366	✓			

Measured by: HB	Audited by: 	Prototype Approval: 
Date: 8-2-5	Date: 08/02/05	Date: 1/7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



